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K6A 1K7  
Canada

Tel (613) 632-5200  
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**20NR-86**  
**Job Sheet 195413**



**Part No:** 20NR-86

**Job Qty:** 1 pcs

**Part Name:** Dual Hook Cage Frame



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 5/22/19

**Job Tracking No:**

**Due Date:** 5/10/19

**Created By:** Eric Larocque

**Type:** SOLD

**Description:**

**Note:** DWG 20NR-86 Rev.1 IPP Rev. A 19.02.11 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                 | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |             | Sign-off    |
|-------|---------------------------|-------|------------|----------|-----------|---------|-----------------------|-------------|-------------|
|       |                           |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time   |             |
| 110   | Large Fab - Welded Assy-1 | 1 pcs | 5/10/19    | 5/10/19  | 0.00      | 1.00    | Large Fab - 1         |             |             |
|       |                           |       |            |          |           |         | Large Fab - 10        |             |             |
|       |                           |       |            |          |           |         | Large Fab - 2         |             |             |
|       |                           |       |            |          |           |         | Large Fab - 3         |             |             |
|       |                           |       |            |          |           |         | Large Fab - 4         |             |             |
|       |                           |       |            |          |           |         | Large Fab - 5         |             |             |
|       |                           |       |            |          |           |         | Large Fab - 6         |             |             |
|       |                           |       |            |          |           |         | Large Fab - 7         |             |             |
|       |                           |       |            |          |           |         | Large Fab - 8         |             |             |
| 115   | QC 9                      | 1 pcs | 5/10/19    | 5/10/19  | 0.00      | 0.00    | Large Fab - 9         |             | MAY 27 2019 |
|       |                           |       |            |          |           |         | QC 9 - 10             |             |             |
|       |                           |       |            |          |           |         | QC 9 - 18             |             |             |
|       |                           |       |            |          |           |         | QC 9 - 24             | DAS 24 9-89 |             |
|       |                           |       |            |          |           |         | QC 9 - 43             |             |             |
|       |                           |       |            |          |           |         | QC 9 - 50             |             |             |
| 120   | QC 5                      | 1 pcs | 5/10/19    | 5/10/19  | 0.00      | 0.00    | QC 9 - 9              |             | MAY 27 2019 |
|       |                           |       |            |          |           |         | QC 5 - 10             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 12             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 17             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 18             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 19             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 22             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 24             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 3              |             |             |
|       |                           |       |            |          |           |         | QC 5 - 43             | DAS 24 9-89 |             |
|       |                           |       |            |          |           |         | QC 5 - 49             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 51             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 58             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 68             |             |             |
|       |                           |       |            |          |           |         | QC 5 - 9              |             |             |
|       |                           |       |            |          |           |         | QC 5 - 50             |             |             |



**Container No:** S184248



**Part:** 20NR-86

**Job No:** 195413

**Serial No/Batch:** S184248

**Revision:** 1

**Inspector:**

**Exp Date:**

**Instructions:**

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Date: 05/27/19

|                                         |         |           |                        |                |
|-----------------------------------------|---------|-----------|------------------------|----------------|
| 130 Powdercoat - 6 Fire Red - B4B 1 pcs | 5/10/19 | 0.00 0.00 | QC 5 - 30              |                |
|                                         |         |           | Powdercoat - 1 - B4B   |                |
|                                         |         |           | Powdercoat - 2 - B4B   |                |
|                                         |         |           | Powdercoat - 3 - B4B   |                |
|                                         |         |           | Powdercoat - 4 - B4B   |                |
| 140 QC 3 1 pcs                          | 5/10/19 | 0.00 0.00 | QC 3 - 10              |                |
|                                         |         |           | QC 3 - 13              |                |
|                                         |         |           | QC 3 - 15              |                |
|                                         |         |           | QC 3 - 17              |                |
|                                         |         |           | QC 3 - 18              |                |
|                                         |         |           | QC 3 - 2               |                |
|                                         |         |           | QC 3 - 28              |                |
|                                         |         |           | QC 3 - 3               |                |
|                                         |         |           | QC 3 - 30              |                |
|                                         |         |           | QC 3 - 34              |                |
|                                         |         |           | QC 3 - 36              |                |
|                                         |         |           | QC 3 - 41              |                |
|                                         |         |           | QC 3 - 51              |                |
|                                         |         |           | QC 3 - 58              |                |
|                                         |         |           | QC 3 - 59              |                |
|                                         |         |           | QC 3 - 68              |                |
|                                         |         |           | QC 3 - 9               |                |
|                                         |         |           |                        | DAS            |
|                                         |         |           |                        | MAY 30 2019 68 |
|                                         |         |           |                        | 9-89           |
| 180 Packaging 3-1 - Stock - B4B 1 pcs   | 5/10/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |                |
|                                         |         |           | Packaging 3 - 2 - B4B  |                |
|                                         |         |           | Packaging 3 - 3 - B4B  |                |
|                                         |         |           | Packaging 3 - 4 - B4B  |                |
|                                         |         |           | Packaging 3 - 5 - B4B  |                |
|                                         |         |           | Packaging 3 - 6 - B4B  |                |
|                                         |         |           | Packaging 3 - 7 - B4B  |                |
|                                         |         |           | Packaging 3 - 8 - B4B  |                |
|                                         |         |           | Packaging 3 - 9 - B4B  |                |
|                                         |         |           | Packaging 3 - 10 - B4B |                |
|                                         |         |           | Packaging 3 - 11 - B4B |                |
|                                         |         |           | Packaging 3 - 12 - B4B |                |
|                                         |         |           | Packaging 3 - 13 - B4B |                |
|                                         |         |           | Packaging 3 - 14 - B4B |                |
|                                         |         |           | Packaging 3 - 15 - B4B |                |
|                                         |         |           | Packaging 3 - 16 - B4B |                |
|                                         |         |           | Packaging 3 - 17 - B4B |                |
|                                         |         |           | Packaging 3 - 18 - B4B |                |
|                                         |         |           | Packaging 3 - 19 - B4B |                |
|                                         |         |           | Packaging 3 - 20 - B4B |                |
|                                         |         |           | Packaging 3 - 21 - B4B |                |
|                                         |         |           | Packaging 3 - 22 - B4B |                |
|                                         |         |           | Packaging 3 - 23 - B4B |                |
|                                         |         |           | Packaging 3 - 24 - B4B |                |
|                                         |         |           | Packaging 3 - 25 - B4B |                |
|                                         |         |           | Packaging 3 - 26 - B4B |                |
|                                         |         |           | Packaging 3 - 27 - B4B |                |
|                                         |         |           | Packaging 3 - 28 - B4B |                |
|                                         |         |           | Packaging 3 - 29 - B4B |                |
|                                         |         |           | Packaging 3 - 30 - B4B |                |
|                                         |         |           | Packaging 3 - 31 - B4B |                |
|                                         |         |           | Packaging 3 - 32 - B4B |                |
|                                         |         |           | Packaging 3 - 33 - B4B |                |
|                                         |         |           | Packaging 3 - 34 - B4B |                |
|                                         |         |           | Packaging 3 - 35 - B4B |                |
|                                         |         |           | Packaging 3 - 36 - B4B |                |
| 190 QC 21 - SA 1 pcs                    | 5/10/19 | 0.00 0.00 | QC 21 - SA - 21        |                |
|                                         |         |           |                        | DAS            |
|                                         |         |           |                        | 21             |
|                                         |         |           |                        | 9-89           |
|                                         |         |           |                        | MAY 31 2019    |



QC 21 - SA - 70

QC 21 - SA - 53

Part Op **110** - 1-Weld as per DWG. Use 8/20NR jig to assemble. 3/8" welds on all parts. See note 1 and 2.  
 Descriptions: **115** - (QC9- Inspect visual per QSI004- Fusion Welds)

**120** - (QC5- Inspect part completeness to step on W/O)

**130** - Fire Red(Ref:4.3.5.10) per QSI005 4.3) Mask as per note 8. START TIME: \_\_\_\_\_ OVEN TEMPERATURE:

FINISH TIME: \_\_\_\_\_

**140** - (QC3- Inspect Part Finish)

**180** - (Identify as per dwg & Stock Location: \_\_\_\_\_)

**190** - (QC21- Final Inspection - Work Order Release)

GA-TBD

## Job BOM

| Part / Item    | Component Name         | Quantity     | Operation                     | Container   |
|----------------|------------------------|--------------|-------------------------------|-------------|
| 20NR-119-1     | Bracket                | 2 pcs (2 ea) | 110-Large Fab - Welded Assy-1 | 5176244 → 2 |
| 20NR-119-10    | Support Tubing         | 2 pcs (2 ea) | 110-Large Fab - Welded Assy-1 | 5164305 → 2 |
| 20NR-119-2-DHC | DHC Back Plate         | 1 pcs (1 ea) | 110-Large Fab - Welded Assy-1 | 5173610 → 2 |
| 20NR-119-3P    | Feeder Support Bracket | 4 pcs (4 ea) | 110-Large Fab - Welded Assy-1 | 5168407 → 1 |
| 20NR-119-4     | Left Top Feeder        | 2 pcs (2 ea) | 110-Large Fab - Welded Assy-1 | 5028459 → 1 |
| 20NR-119-4B    | Bottom Left Feeder     | 2 pcs (2 ea) | 110-Large Fab - Welded Assy-1 | 5168401 → 0 |
| 20NR-119-5     | Top Right Feeder       | 2 pcs (2 ea) | 110-Large Fab - Welded Assy-1 | 5164329 → 2 |
| 20NR-119-5B    | Bottom Right Feeder    | 2 pcs (2 ea) | 110-Large Fab - Welded Assy-1 | 5164382 → 0 |
| 20NR-119-6     | Upper Funnel Guide     | 4 pcs (4 ea) | 110-Large Fab - Welded Assy-1 | 5164335 → 2 |
| 20NR-119-7     | Lower Funnel Guide     | 4 pcs (4 ea) | 110-Large Fab - Welded Assy-1 | 5168821 → 4 |
| 20NR-119-8     | Front Support          | 4 pcs (4 ea) | 110-Large Fab - Welded Assy-1 | 5170080 → 4 |
| 20NR-119-9-DHC | Guard                  | 1 pcs (1 ea) | 110-Large Fab - Welded Assy-1 | 5164256 → 4 |
| 20NR-120-5     | Funnel Tab             | 2 pcs (2 ea) | 110-Large Fab - Welded Assy-1 | 5173354 → 1 |
|                |                        |              |                               | 5164391 → 2 |

## Job Allocations

| Operation                     | Component Part | Required | Inventory | Allocated |
|-------------------------------|----------------|----------|-----------|-----------|
| 110-Large Fab - Welded Assy-1 | 20NR-119-1     | 2        | 23        | 0         |
|                               | 20NR-119-10    | 2        | 8         | 0         |
|                               | 20NR-119-2-DHC | 1        | 4         | 0         |
|                               | 20NR-119-3P    | 4        | 5         | 0         |
|                               | 20NR-119-4     | 2        | 10        | 0         |
|                               | 20NR-119-4B    | 2        | 8         | 0         |
|                               | 20NR-119-5     | 2        | 10        | 0         |
|                               | 20NR-119-5B    | 2        | 8         | 0         |
|                               | 20NR-119-6     | 4        | 16        | 0         |
|                               | 20NR-119-7     | 4        | 16        | 0         |
|                               | 20NR-119-8     | 4        | 10        | 0         |
|                               | 20NR-119-9-DHC | 1        | 4         | 0         |
|                               | 20NR-120-5     | 2        | 11        | 0         |

## Part Specifications

Specifications could not be found.

Plex 5/22/19 10:32 AM dart.larocque.eric

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119-3  
MISSING 11